

Date: Thursday, 6/15/2006 1:56:03 PM  
User: Kim Johnston

## Process Sheet

Split  
SB 06/09/28  
split  
80 06/10/23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY  
Job Number : 27590 Part Number : D3065041  
Estimate Number : 10385 Drawing Number : D3065 REV A2  
P.O. Number : N/A Project Number : N/A  
This Issue : 6/15/2006 S.O. No. : N/A Drawing Revision : A2  
Prsht Rev. : NC Material : N/A  
First Issue : 6/15/2006 Type : SMALL / MED FAB Due Date : 7/2/2006 Qty: 60 Um: Each  
Previous Run : 26928  
Written By :  
Checked & Approved By :  
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 27590A STEP SPACER



Comment: Sub-Component STEP SPACER

2.0 27590B STEP SPACER



Comment: Sub-Component STEP SPACER

3.0 27590C STEP LEG



Comment: Sub-Component STEP LEG

4.0 27590D STEP SPACER



Comment: Sub-Component STEP SPACER

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s) 32

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-1	Spacer	B 27590A - 32 mx

B 27590A - 32 mx B 27590A - 4 mx

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)





Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-3	Spacer	B 27590B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/13	10	<del>54</del> D 3065-5 <del>54</del> D 3065-7 + 2 D 3065-1 <del>holes</del> were out of tolerance	 Q921P	<del>Scrap</del> Scrap + destroy	SP 06/10/23	 06.10.23	 Q921P	 06.10.23

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 D30655 Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) *76*

Step Leg

Pick:

Qty	Part Number	Description	Batch
2	D3065-5	Leg	<i>B27590c</i>

8.0 D30657 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) *33*

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-7	Spacer	<i>B27590 D - 33 mx B26928 D - 6mx</i>

9.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
30	MS20470AD4-4	Rivet	<i>m100993</i>

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

*mf. 06/10/23*

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JB 06/10/24*

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W1919 420*

*RE. 06.10.24*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion



u 06.11.15



DESIGN	CP	DRAWN BY	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. <b>D3065</b>
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY	
A	02.09.11	NEW ISSUE	REV. A	SHEET 1 OF 5
A1	03.02.13 CP	ADD SLOTS TO D3065-5	SCALE	1:2
A2	03.02.27 CP	0.531 WAS 0.410		

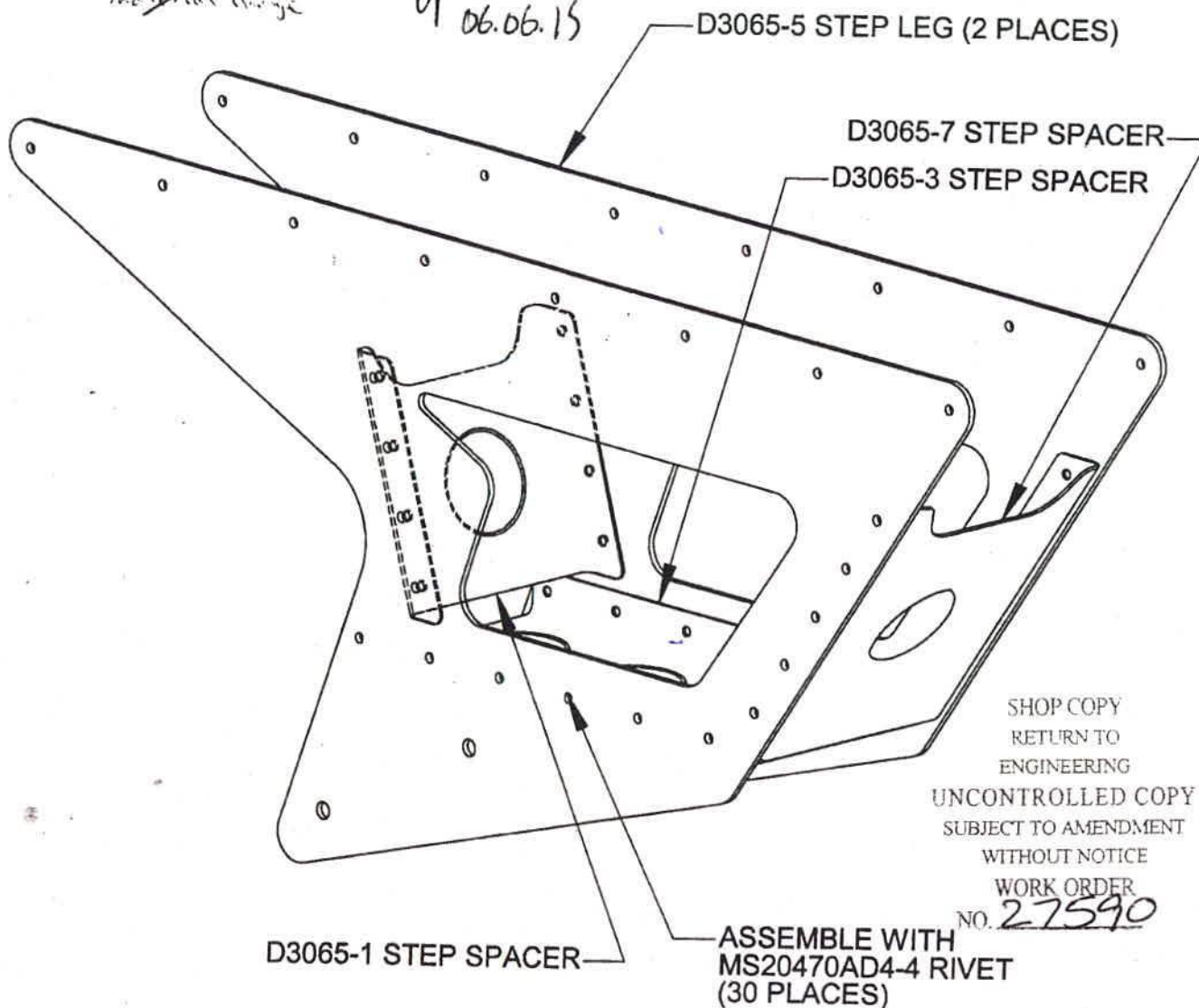
RELEASED  
02.01.20 #

UNDER REVIEW

C.6.06.02 CB

material change

OK CP  
06.06.15



## D3065-041 STEP LEG ASSEMBLY

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Date: Wednesday, 15/11/2006 3:42:02 PM

User: Linda Lacelle

## JOB HISTORY : DETAIL

<b>Job Number</b> : 27590	<b>Customer</b> : Dart Helicopters Services
<b>Estimate Number</b> : 10385	<b>DWG Name</b> : HI-STEP LEG ASSEMBLY
<b>Purchase Order #</b> :	<b>Part Number</b> : D3065041
<b>Complete Date</b> : 29/09/2006 11:42:21	<b>DWG Number</b> : D3065 REV A2 <b>Rev.</b> : A2

DUE DATE	ORDERED	DELIVERED
02/07/2006	60	25

<b>1.0 D30651-Step Spacer SUB-Component/Sub-job</b>	
DATE	EMPLOYEE
29/09/2006	BOUC01: Boucher, Sylvie
TYPE	Qty
	1.000
	\$12.01
27590A	
<b>Subtotal:</b>	CTD: 1 \$12.01

<b>3.0 D30655-Step Leg SUB-Component/Sub-job</b>	
DATE	EMPLOYEE
29/09/2006	LACE01: Lacelle, Linda
TYPE	Qty
	120.000
	\$6211.67
27590C	
29/09/2006	LACE01: Lacelle, Linda
TYPE	Qty
	5.000
	\$258.82
27590C	
<b>Subtotal:</b>	CTD: 125 \$258.82

<b>4.0 D30657-Step Spacer SUB-Component/Sub-job</b>	
DATE	EMPLOYEE
29/09/2006	BOUC01: Boucher, Sylvie
TYPE	Qty
	1.000
	\$11.06
27590D	
<b>Subtotal:</b>	CTD: 1 \$11.06

<b>5.0 D30651-Step Spacer INVENTORY ITEM</b>	
DATE	EMPLOYEE
29/09/2006	BOUC01: Boucher, Sylvie
TYPE	D30651
Qty	25.000
COST	\$300.22
Lot # 27590A Qty. 25	
<b>Subtotal:</b>	QTD: 0 CTD: 25 \$300.22

<b>6.0 D30653-Step Spacer INVENTORY ITEM</b>	
DATE	EMPLOYEE
28/09/2006	BOUC01: Boucher, Sylvie
TYPE	D30653
Qty	25.000
COST	\$380.68
Lot # 21125 Qty. 1	
Lot # 22366 Qty. 3	
Lot # 22959 Qty. 7	
Lot # 23618 Qty. 2	
Lot # 26211B Qty. 1	
Lot # 26452B Qty. 6	
Lot # 26928B Qty. 5	
<b>Subtotal:</b>	QTD: 0 CTD: 25 \$380.68

<b>8.0 D30657-Step Spacer INVENTORY ITEM</b>	
DATE	EMPLOYEE
29/09/2006	BOUC01: Boucher, Sylvie
TYPE	D30657
Qty	25.000
COST	\$276.58
Lot # 27590D Qty. 25	
<b>Subtotal:</b>	QTD: 0 CTD: 25 \$276.58

<b>9.0 MS20470AD44-Rivet, Universal Head INVENTORY ITEM</b>	
DATE	EMPLOYEE
29/09/2006	BOUC01: Boucher, Sylvie
TYPE	MS20470AD44
Qty	1850.000
COST	\$16.47
Lot # 100993 Qty. 1807	
Lot # 17944 Qty. 43	
<b>Subtotal:</b>	QTD: 0 CTD: 1850 \$16.47

Date: Wednesday, 15/11/2006 3:42:02 PM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 27590	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 10385	<b>DWG Name</b>	: HI-STEP LEG ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D3065041
<b>Complete Date</b>	: 29/09/2006 11:42:21	<b>DWG Number</b>	: D3065 REV A2
		<b>Rev.</b>	: A2

**10.0 SMALL FAB 1 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
28/09/2006	DROU02: Drouin, Steven	Run	0.000	12.15	\$167.06	12.15	486.00
29/09/2006	BOUC01: Boucher, Sylvie	Run	25.000	0.00	\$0.00	0.01	0.40
16/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	2.25	\$25.88	2.25	90.00
17/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	5.25	\$60.38	5.25	210.00
18/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	5.00	\$57.50	5.00	200.00
18/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	2.50	\$28.75	2.50	100.00
19/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	9.75	\$112.13	9.75	390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	9.75	\$112.13	9.75	390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	-9.75	\$-112.13	-9.75	-390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	1.00	\$11.50	1.00	40.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.83	\$9.55	0.83	33.20
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.92	\$10.58	0.92	36.80
23/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	4.33	\$49.80	4.33	173.20
23/10/2006	BOUC01: Boucher, Sylvie	Run	0.000	3.17	\$65.65	3.17	126.80
24/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.42	\$4.83	0.42	16.80

**Subtotal:** QTD: 25 CTD: 0 47.57 \$2506.81

**11.0 QC5 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
29/09/2006	BOUC01: Boucher, Sylvie	Run	25.000	2.32	\$48.05	2.32	60.32

**Subtotal:** QTD: 25 CTD: 0 2.32 \$108.37

		TIME	COST
	Machine Time:	49.90	\$1963.52
	Labor:	49.89	\$651.66
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$973.95
	SUB-COMPONENT (SUB-JOB):		\$6493.56
<b>Total:</b>			\$10082.69

COST PER UNIT: \$403.30



Date: Thursday, 6/15/2006 1:56:33 PM  
 User: Kim Johnston

## Process Sheet

*split*  
*SR 06/09/28*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY  
 Job Number : 27590 -1  
 Estimate Number : 10385  
 P.O. Number :  
 This Issue : 6/15/2006 S.O. No. :  
 Prsht Rev. : NC Drawing Number : D3065 REV A2  
 First Issue : 6/15/2006 Type : SMALL /MED FAB Project Number : N/A  
 Previous Run : 26928 Drawing Revision : A2  
 Written By :  
 Checked & Approved By : *06.06.15*  
 Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Part Number : D3065041  
 Drawing Number : D3065 REV A2  
 Project Number : N/A  
 Drawing Revision : A2  
 Material :  
 Due Date : 7/2/2006 Qty: 60 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 27590A STEP SPACER



Comment: Sub-Component STEP SPACER *D3065-1*

2.0 27590B STEP SPACER



Comment: Sub-Component STEP SPACER *D3065-1 D3065-3*

3.0 27590C STEP LEG



Comment: Sub-Component STEP LEG *D3065-5*

4.0 27590D STEP SPACER



Comment: Sub-Component STEP SPACER *D3065-7*

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-1	Spacer	<i>B27590A (1)</i>

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-3	Spacer	<i>B21125 (1) 23418 (2) B22366 (3) 232118 (1) B22959 (4) 26452B (6) 269286 (5)</i>



Date	Step	Description	init'd <del>Dr</del> SIS	action Corrective	Sign Date	Verifier	Approval	Approval
06/09/29	10	<del>Dr</del> 1 D305-7 1 D305-1 Roles were over size	06/09/29	inspect + replace it	SB 06/09/29	06-09-29	<del>Dr</del> V. [Signature]	[Signature] 06-09-29

5. 06/10/29

File: Thursday, 6/15/2006 1:56:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Leg

Pick:

Qty Part Number Description Batch

2 D3065-5 Leg 27590C

8.0

D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Spacer

Pick:

Qty Part Number Description Batch

1 D3065-7 Spacer B27590D

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total: 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

30 MS20470AD4-4 Rivet M17944 (43) M100993 SAD 06/09/28

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

SAD 06/09/28

25

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/28

25

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA18 #17

SA

SA 06/09/29 25



Thursday, 6/15/2006 1:56:03 PM  
Klm Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/10/02

Job Completion



U 06/09/02

**DART**

DESIGN	CP	DRAWN BY	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. <b>D3065</b>	REV. A SHEET 1 OF 5
DATE	02.09.11			TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11			NEW ISSUE	
A1	03.02.13 CP			ADD SLOTS TO D3065-5	
A2	03.02.27 CP			0.551 WAS 0.410	

RELEASED  
02.01.20 #

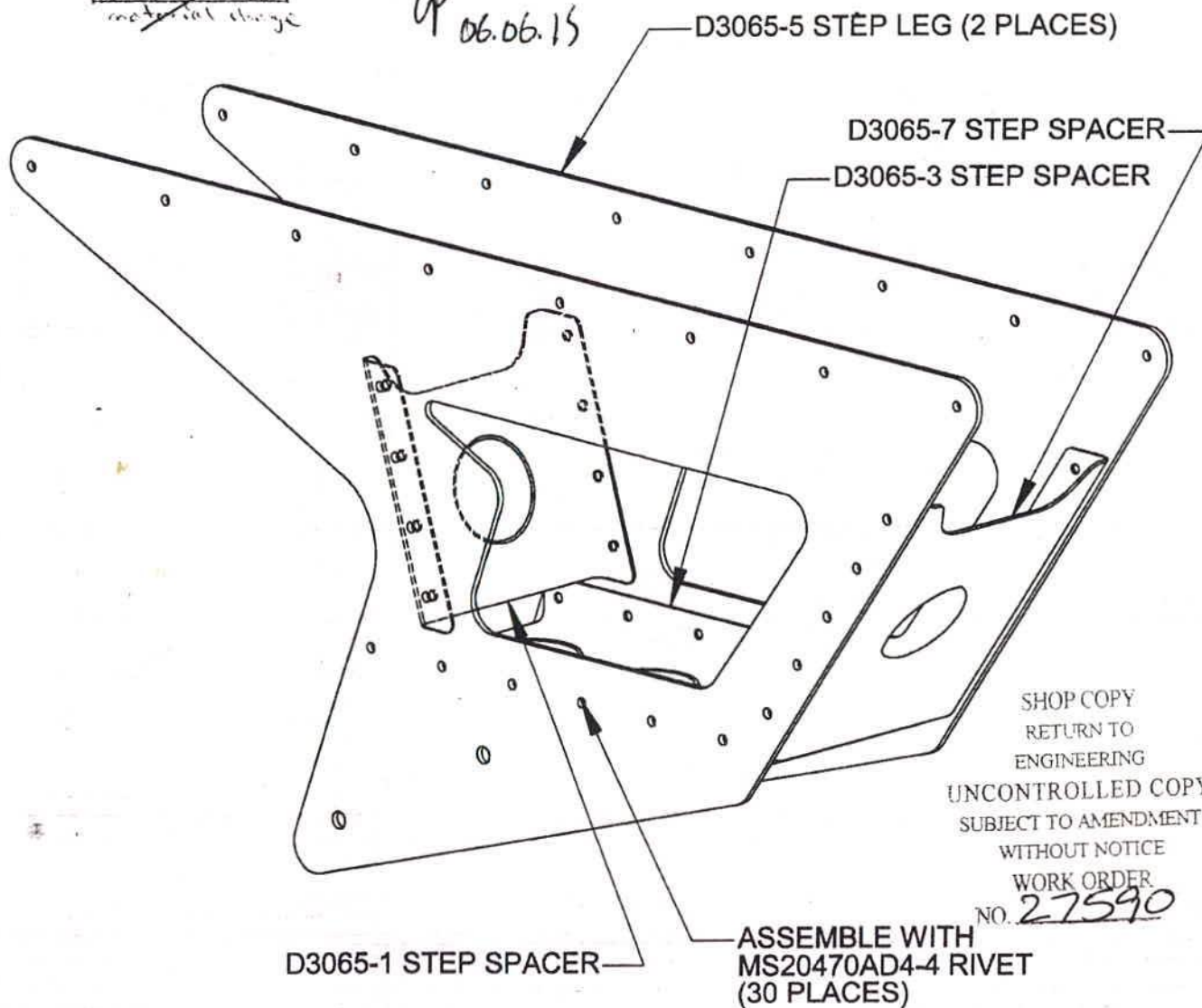
**UNDER REVIEW**

C6.06.02 CB

material change

OK CP

06.06.15

**D3065-041 STEP LEG ASSEMBLY**

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Date: Thursday, 6/15/2006 1:56:06 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 27590B		
Estimate Number	: 10378		
P.O. Number	:	Part Number	: D30653
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D3065 REV. A2
Print Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : SMALL / MED FAB	Drawing Revision	: A2
Previous Run	: 26928B	Material	:
Written By	: <u>JA 06-06-15</u>	Due Date	: 7/2/2006 Qty: 60 Um: Each
Checked & Approved By	: <u>JA 06-06-15</u>		
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2287 sf(s)/Unit Total: 13.7214 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
(M2024T3S.040) Batch: M19295

M101417

MM 06 07 10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D  
Dwg Rev: A2  
Prog Rev: A2

MM 06 07 10  
MM 06 09 05  
~~MM 06 07 10~~

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 07 10  
MM 06 09 05  
60

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JA 06 06 06  
60  
counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr Stack

5AD  
06:09:10  
60



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	B	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-13	2	61 Parts scrap. W.J. Tip was too big, causing the holes Ø.128 to be too large. Ø.128 → Ave .138 ~ .142. operator error.	<i>[Signature]</i> 06/07/13	Ensure operator verifies set-up before starting. destroy stack & replace.	<i>[Signature]</i> 06/07/05	<i>[Signature]</i> 06/09/06	<i>[Signature]</i> 06/07/13	<i>[Signature]</i> 06/07/13
06/09/16	6	1 part was bend out of Tol	<i>[Signature]</i> 06/09/16	Scrap + destroy	<i>[Signature]</i> 06/10/14	<i>[Signature]</i> 06/10/16	<i>[Signature]</i> 06/10/16	<i>[Signature]</i> 06/10/16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: *06/11/15*

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Thursday, 6/15/2006 1:56:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27590B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

*mf. SB 06/10/16*  
*06/10/12*

59

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-10-16 (59)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*g.m. 06/10/16*

(59)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*mf. 06/10/17*

59

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 06/11/15*

59

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/11/15*

59

Job Completion



*U 06-11-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**

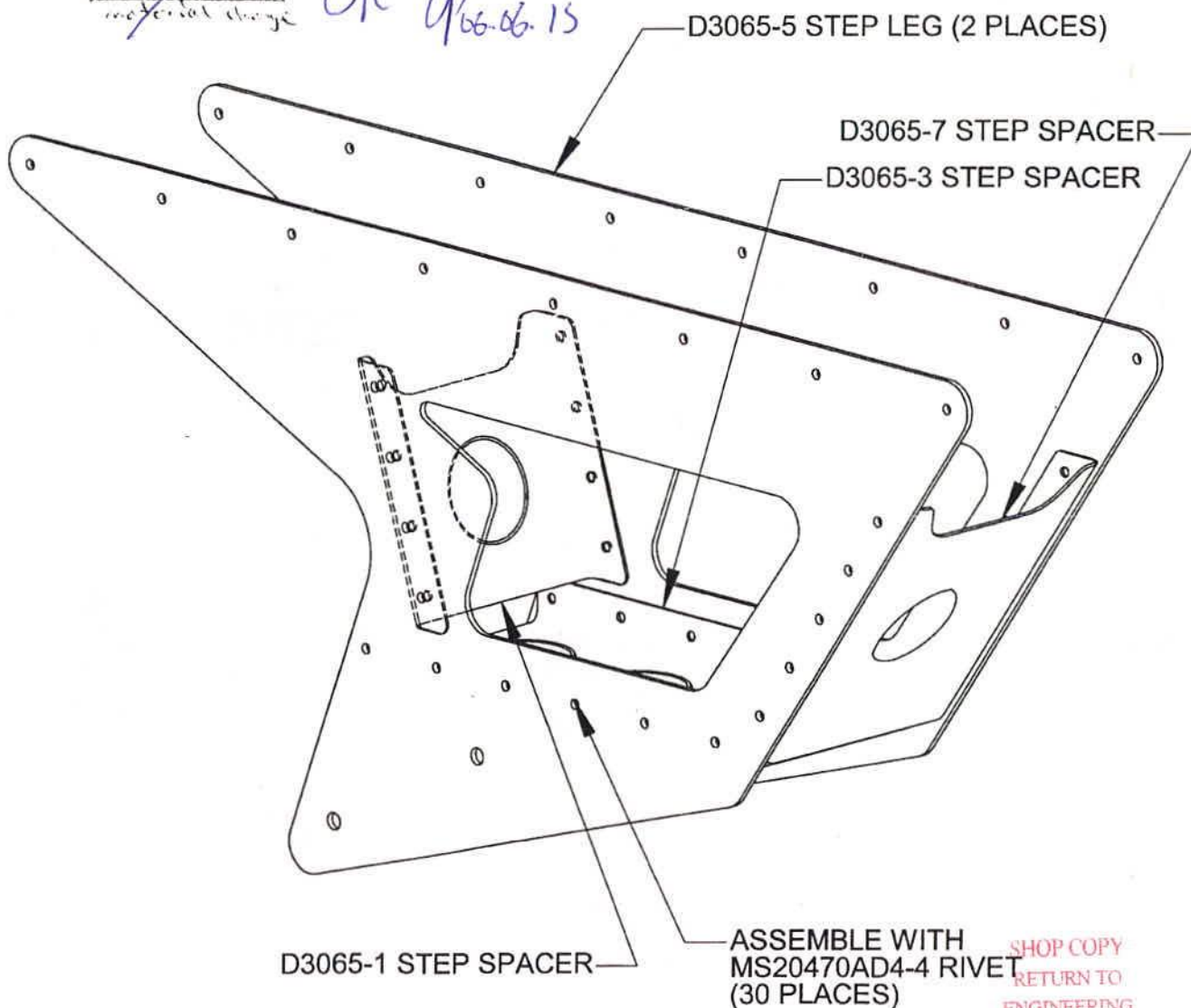
DESIGN	CP	DRAWN BY	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. <b>D3065</b>	REV. A SHEET 1 OF 5
DATE	02.09.11			TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11			NEW ISSUE	
A1	03.02.13 CP			ADD SLOTS TO D3065-5	
A2	03.02.27 CP			0.531 WAS 0.410	

RELEASED  
02.01.20 #

**UNDER REVIEW**

06.06 02 CB  
material change

OK 06.06.15

**D3065-041 STEP LEG ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27590B

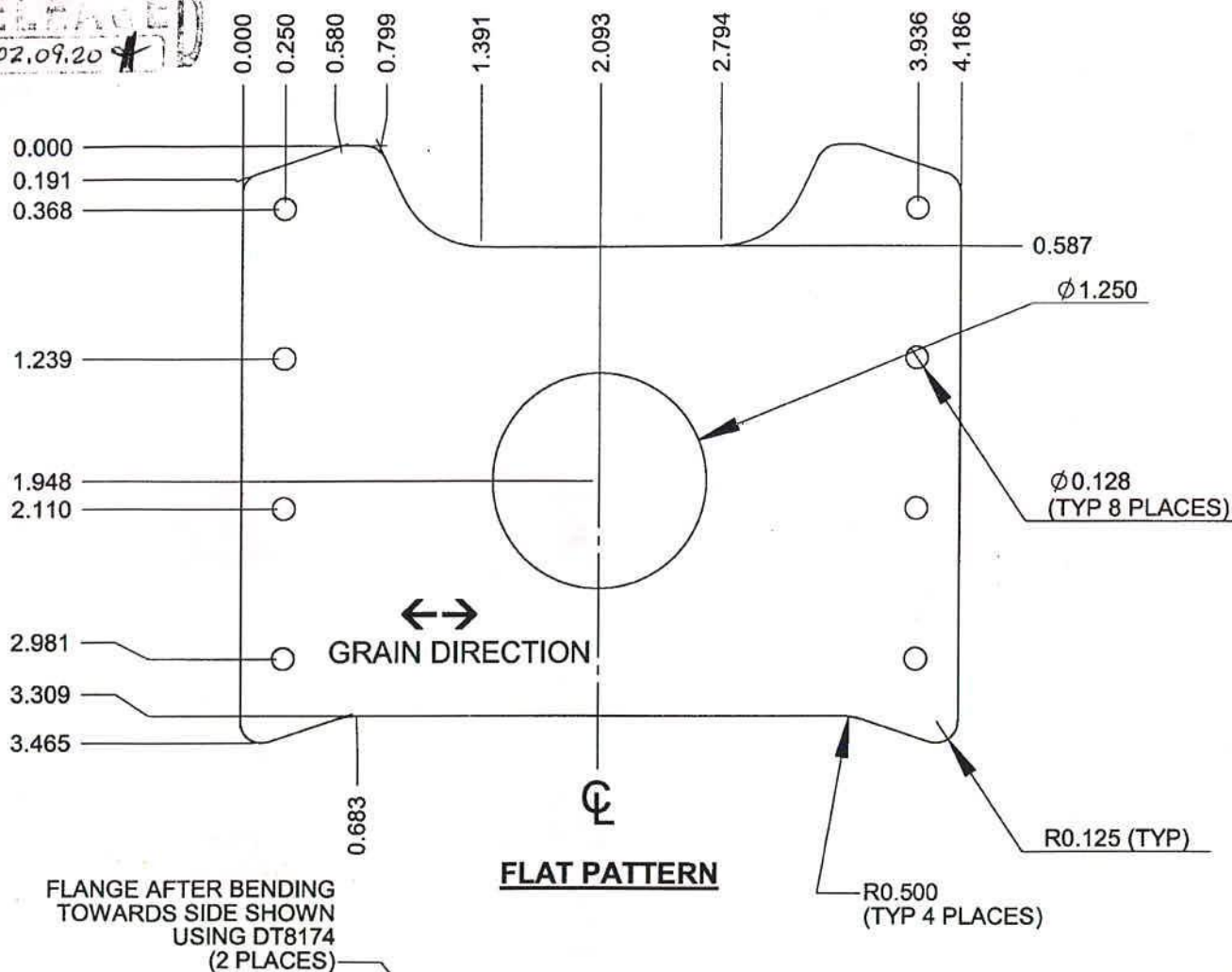
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. A SHEET 2 OF 5
DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

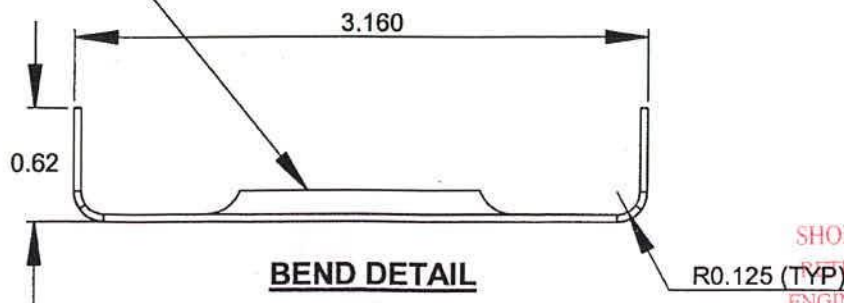
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02.09.20



UNDER REVIEW

cc. 06.01.15  
material change

O/K *CP* 06.06.15



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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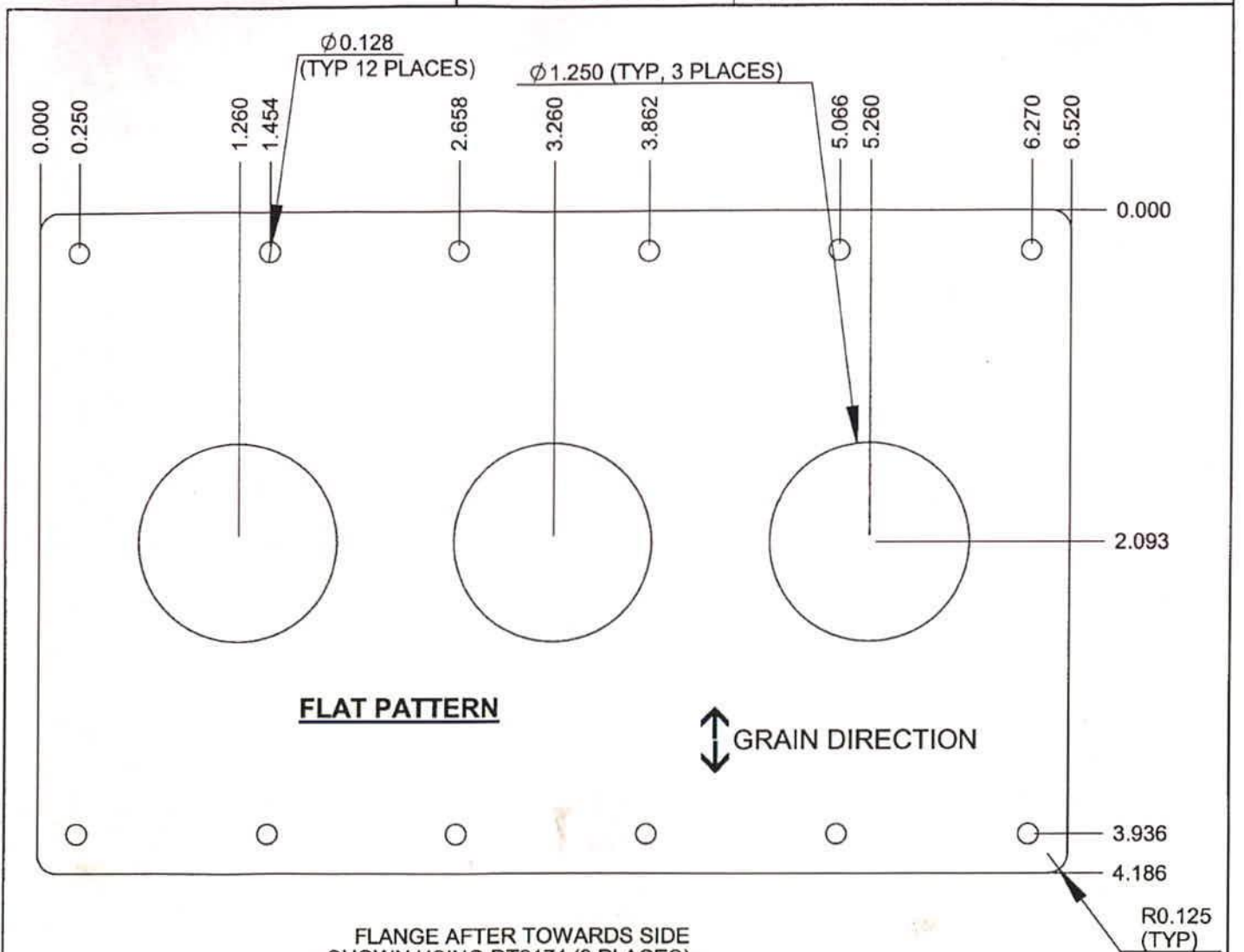


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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



UNDER REVIEW

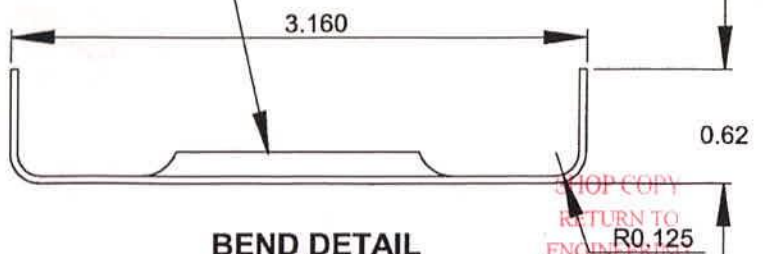
06.06.02 CB

material change

OK

*CP*

06.06.15



**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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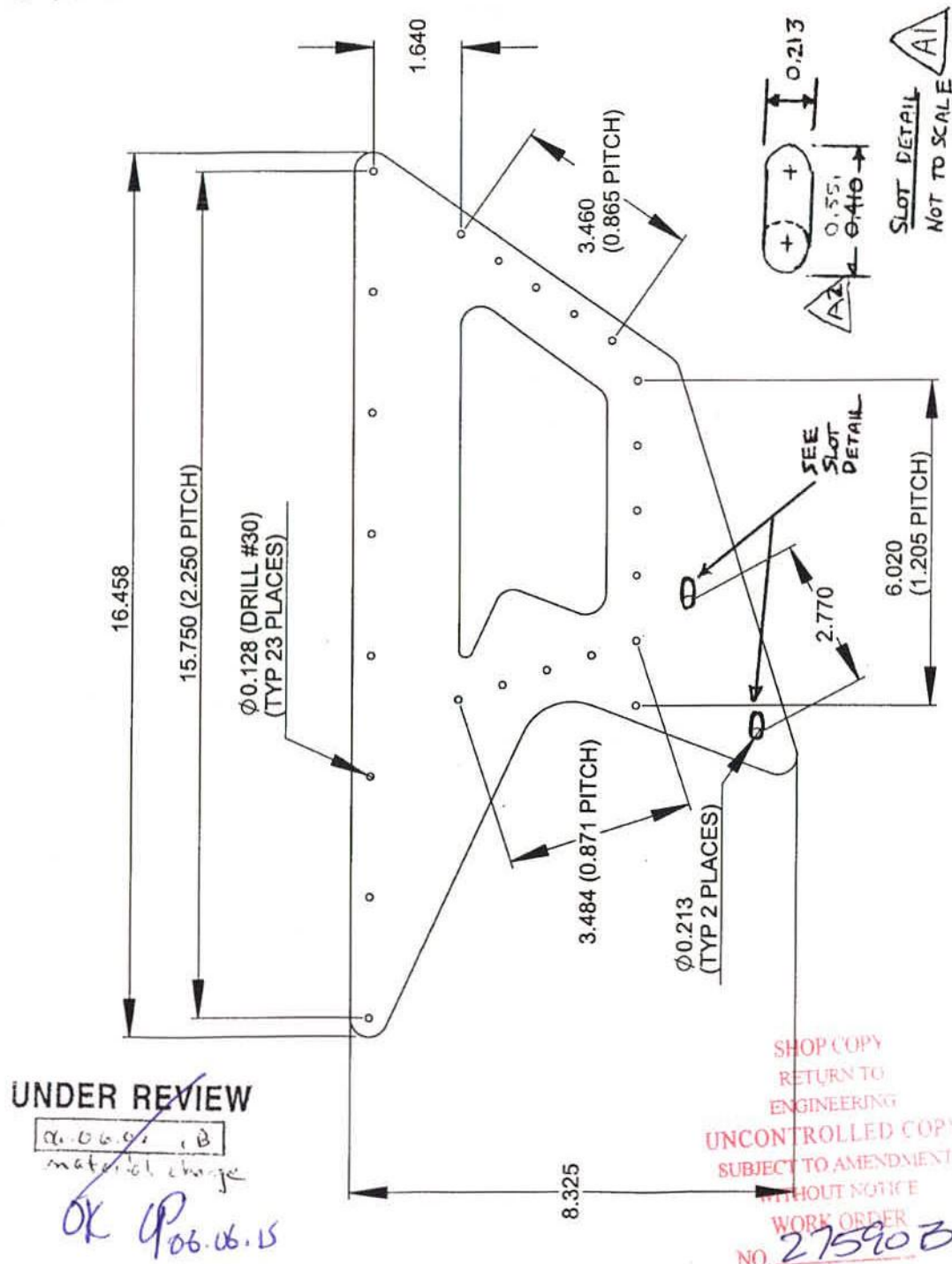
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED  
02.09.20 #**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5 SLDPR1"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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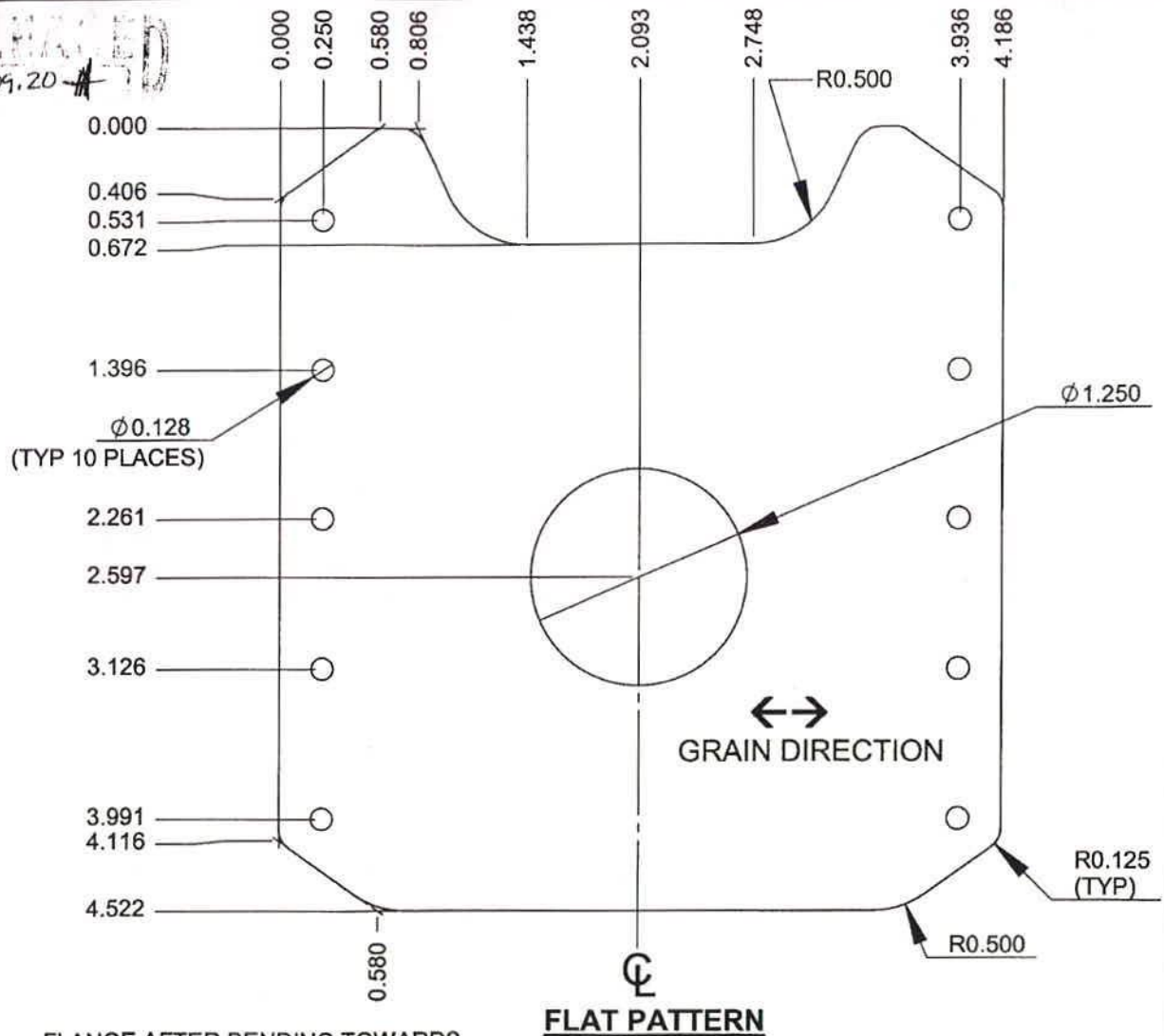
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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

RELEASED  
02.09.20 *[Signature]*

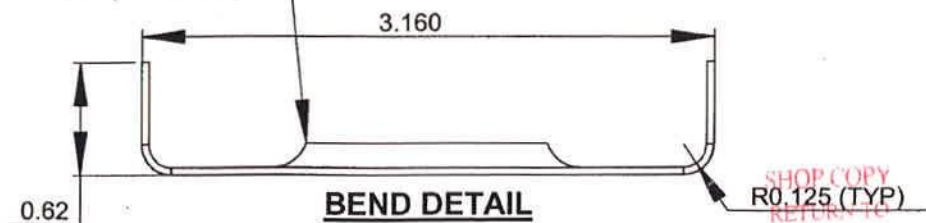


FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)

UNDER REVIEW

*change CB*  
*material change*

*OK [Signature] 06.06.13*



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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